

Split

Work Order ID 59245 -1

May 28, 2010 7:49:48 AM

~~PRELIMINARY ISSUE~~

Accept

N/A

Page 1

Item ID: D4127-1

Revision ID: PRELIM

Item Name: Lug

Start Date: 28/05/2010 Start Qty: 5.00

Required Date: 28/05/2010 Req'd Qty: 5.00

Reference:

1.0
JUL 10 5-28

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Cust Item ID:

Customer:

N/A

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4127

Rev A JUL 10 5-28

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

Cut as per Dwg

DWG REV: PRE

PROG REV: LIM

DEBURR IF REQUIRED

0.00

1310-5-28

(5)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

1310-5-28

Work Order ID 59245

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Page 2

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Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Mill Conv

Conventional Milling Machine

Memo

MILL RAIDS, DRILL HOLES AS PER DWG
GRIND RAD .060"-.100" BY HAND

0.00

0.00

Jun 10. 05. 28 (1)

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Jun 10. 05. 28 (1)

150



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Jun 10. 05. 28 (1)

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Page 3

Item ID: D4127-1
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Item Name: Lug

Accept



Setup Start



Stop



Start Date: 28/05/2010 Start Qty: 5.00
Required Date: 28/05/2010 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Hand Finish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

10/05/28

1 0

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

Memo

M114207 START: 11:00am
TEMP: 320°F
FIN: 1:30am
=> 10/05/28

1 0

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

10/05/28

Work Order ID 59245

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Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID*

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PM
05/28/10 9:52 AM

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 10-5-28
N/A.
10-05-28
10.05.28
PART IS GOOD TO
RELEASE REV. A &
TRIAL FIT.

POSITIVE RECALL
EFFECTIVE 10-5-28
RELEASED AUTH DATE

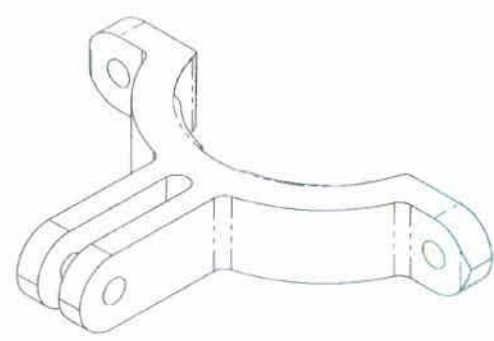
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype[illegible]

Measured by: <i>IB</i>	Audited by: <i>IR</i>	Prototype Approval:	N/A
Date: <i>10-5-28</i>	Date: <i>10.05.28</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

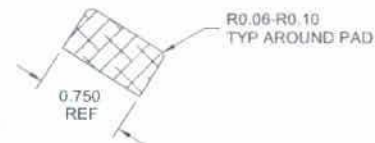
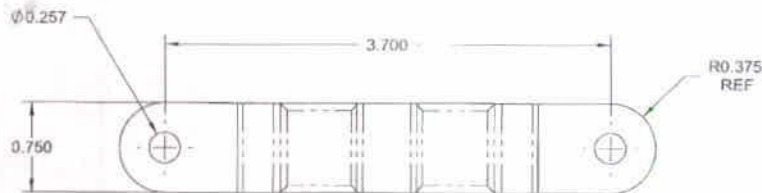
w/o 59245



D4127-1 LUG

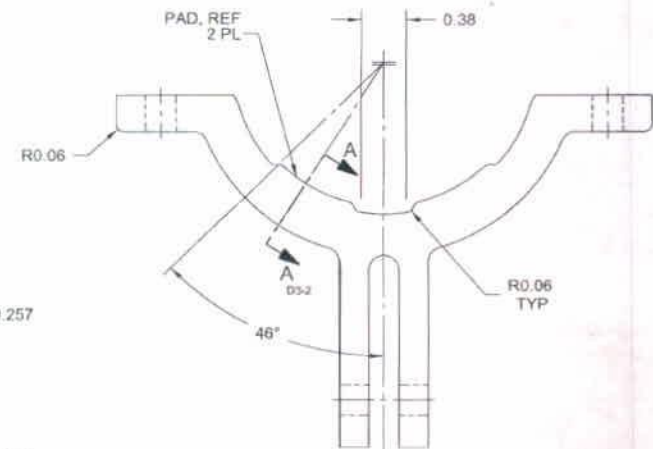
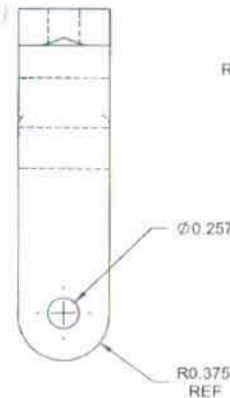
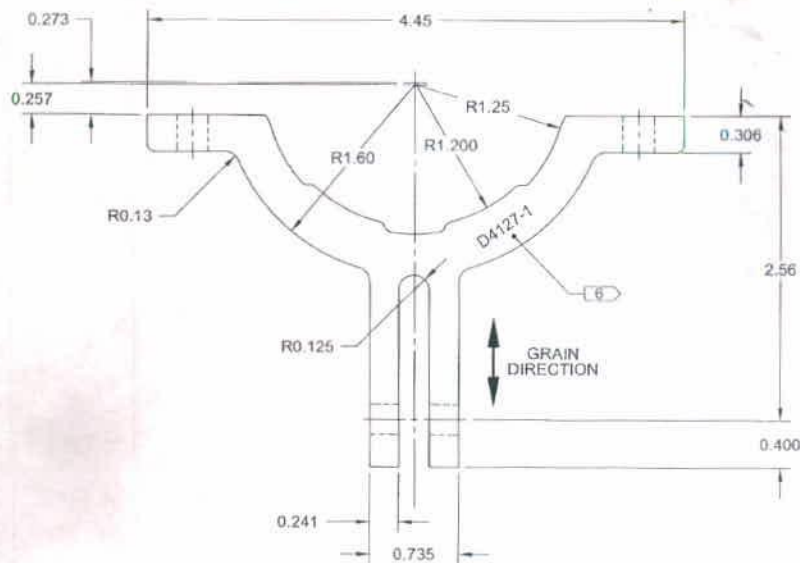
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DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.05.26			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4127	REV. A SHEET 1 OF 2
TITLE LUG	SCALE NTS
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SECTION A-A B2-2
SCALE 1X

w/o 59245

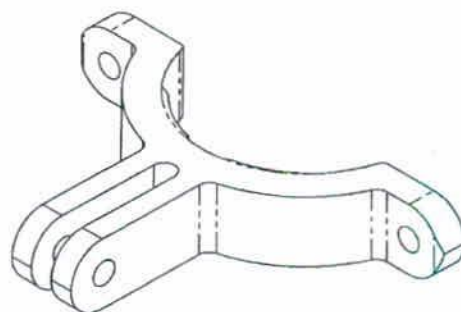


D4127-1 LUG

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, BAR, OR EXTRUSION
PER QQ-A-200/8, QQ-A-225/8, ASTM B209, ASTM B211, OR ASTM B221
(REF DART SPEC. M6061T6B, M6061T6S)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.19 lbs

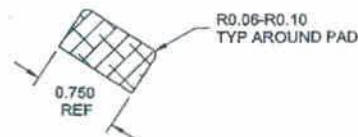
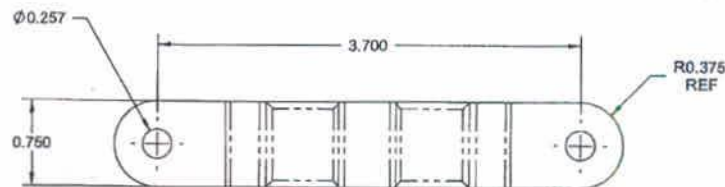
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CHECKED		DRAWING NO.	REV. A
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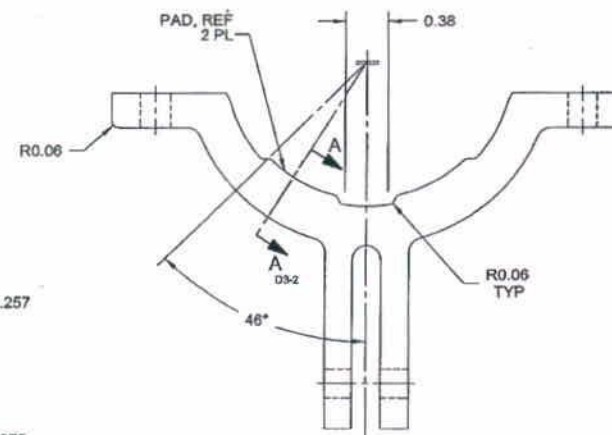
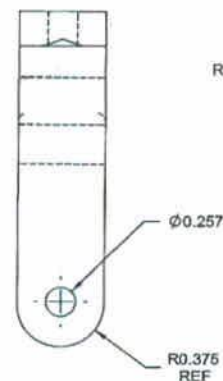
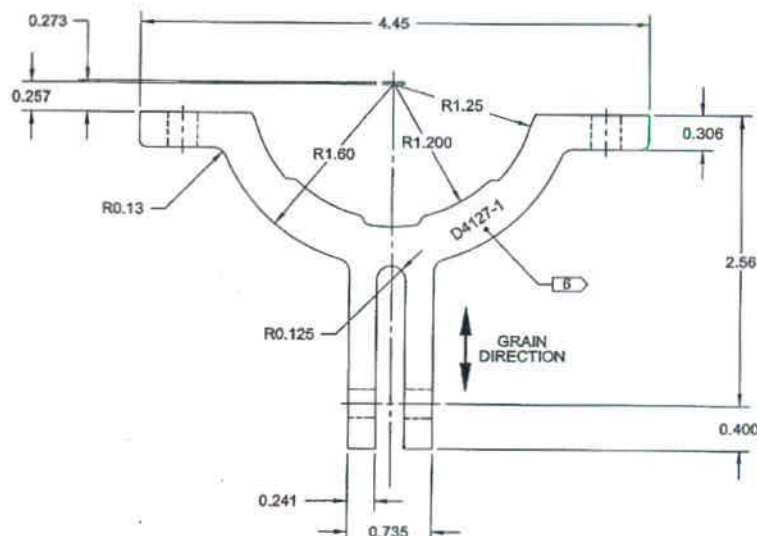
D4127-1 LUG

RELEASED
10/05/26

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REV.			BY	DATE
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
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SECTION A-A B2-2
SCALE 1X



D4127-1 LUG

RELEASED
10/05/26

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